



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2857-1
Job Sheet 168075



Part No: D2857-1

Job Qty: 10 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/18/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Pacific Crown Helicopters Pty Ltd (CPAC105)

21 Enterprise Street Caloundra West, Queensland, 4551 Australia ph:011 617 5438 1299 fx:(61) 7 5438 1277.

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/17/17	11/17/17	0.00	0.00	Start Up Machining		KT 17-02-07
100	Bandsaw	10 pcs	11/17/17	11/17/17	0.00	0.35	Bandsaw1		KT 17-12-07
110	CNC Vertical Machining	10 pcs	11/17/17	11/17/17	0.13	5.53	HAAS 1		KT 17-12-07
130	QC	10 pcs	11/17/17	11/17/17	0.00	0.00	QC8		KT 17-12-07
140	HandFinish	10 pcs	11/17/17	11/17/17	0.00	0.22	HandFinish1		BR 17-12-11
160	Powdercoat	10 pcs	11/18/17	11/18/17	0.00	0.15	Powdercoat1		BR 17-12-13
170	QC	10 pcs	11/18/17	11/18/17	0.00	0.00	QC3		
180	Packaging	10 pcs	11/18/17	11/18/17	0.00	0.00	Packaging3	Stop	
190	QC21-SA	10 Ea	11/18/17	11/18/17	0.00	0.00	QC21		DEC 14 2017

Part Op 100 - Cut blanks 4.425"

Descriptions: 110 - 1-Machine per folio FA940 DWG REV: 2-Deburr any rough edges

160 - START TIME: 1:25 FINISH TIME: 1:55 OUT: 3:20

M138462

M137762

4.5" x 10 piece

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.000X01.250	4	26	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches ± 0.010	4.310 4.290		
2	Hinge Bracket	4.000inches ± 0.010	4.010 3.990		
3	Hinge Bracket	0.340inches ± 0.010	0.350 0.330		
4	Hinge Bracket	1.110inches ± 0.005	1.115 1.105		
5	Hinge Bracket	1.790inches ± 0.010	1.800 1.780		
6	Hinge Bracket	1.320inches ± 0.005	1.325 1.315		

DART
AEROSPACE
S018550



Hinge Bracket

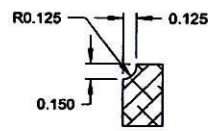
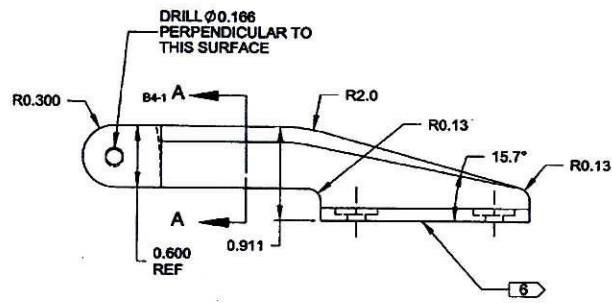
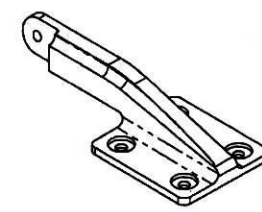
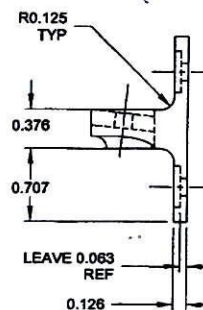
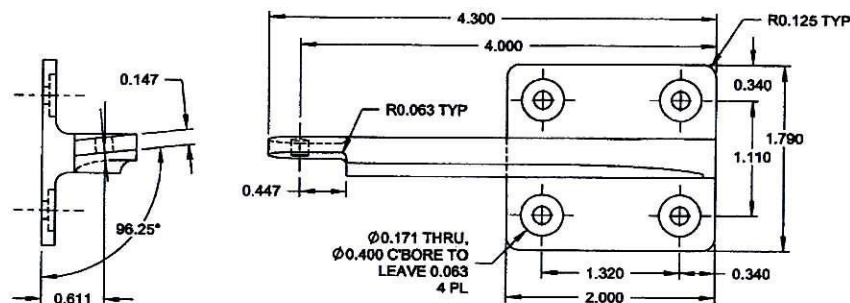
PART NO: D2857 - 1
Revision:
Operation: Packaging
Change No:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 12/07/17
Job No: 168075

7	Hinge Bracket	2.000inches ± 0.010	2.010 1.990
8	Hinge Bracket	0.340inches ± 0.010	0.350 0.330
9	Hinge Bracket	0.447inches ± 0.010	0.457 0.437
10	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171
11	Hinge Bracket	0.147inches ± 0.010	0.157 0.137
12	Hinge Bracket	0.376inches ± 0.010	0.386 0.366
13	Hinge Bracket	0.126inches ± 0.010	0.136 0.116
14	Hinge Bracket	0.063inches ± 0.010	0.073 0.053
15	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166
16	Hinge Bracket	0.911inches ± 0.010	0.921 0.901
17	Hinge Bracket	0.600inches ± 0.010	0.610 0.590
18	Hinge Bracket	0.125inches ± 0.010	0.135 0.115
19	Hinge Bracket	0.150inches ± 0.010	0.160 0.140

Plex 11/10/17 12:36 PM dart.lacelle.linda



SECTION A-A

D2857-1 HINGE BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168 075

DAS
30
9-89

NOV 13 2017

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A3-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	JP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2857	REV. C
TITLE HINGE BRACKET	SHEET 1 OF 2
SCALE NTS	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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